

Work Order ID 82285

82285

Page 1

March-28-12 12:53:54 PM

Item ID: D350-567-141

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Floor Window Closeout Installation

Start Date: 28/03/2012 Start Qty: 6.00 ***6***

Cust Item ID:

Required Date: 11/04/2012 Req'd Qty: 6.00 ***6***

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 12/03/28 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

DSI 9590

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-567-141 CHG002

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS 16 12/10/16 JB

ML5 12-0924

6

12/09/25 JB

6

DAS 16 12/10/16 JB

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 82285

82285

Page 2

March-28-12 12:53:54 PM

Item ID: D350-567-141

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Floor Window Closeout Installation

Stop ***NS2***

Start Date: 28/03/2012 Start Qty: 6.00 ***6***

Cust Item ID:

Required Date: 11/04/2012 Req'd Qty: 6.00 ***6***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | Packaging | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D350-567-141 | | | | | | | | |
| | Location: <u>59A</u> | | | | | | | | |
| | <u>REQ A</u> | | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

SL 12/10/12 SP

MLJ 12-10-16
MLJ 12-10-16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 82285

82285

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 11.11.09 new issue DD verf:JLM
12.01.23 AS PER ECN12-511 DD VERF:EC
AS PER ECN12-537 DD VERF:EC
IPP REV:B
IPP REV:C 12.03.05

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|--|--|--------------|----|--|--|-----|---|----------|---|----|--|--|--|
| D3802-1 | | Manufactured | No | | | 110 | f | 557.7500 | 2 | 12 | | | |
| <div style="display: flex; justify-content: space-between;"> S *D3802-1* ** ✓ S </div> | | | | | | | | | | | | | |

Window Seal

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST412 | 557.75 | |
| 56881 | 0.75 | |
| 81021 | 57 | |
| 81868 | 500 | |
| | 81868 | |

(D3802-1-024) CUT (1) AT 24" AS PER DWG, PER KIT.

| | | | | | | | | | | | | | |
|---|--|--------------|----|--|--|-----|------|--------|---|--|--|--|--|
| D4434-041 | | Manufactured | No | | | 110 | Each | 0.0000 | 6 | | | | |
| <div style="display: flex; justify-content: space-between;"> -3 *D4434-041* ** ✓ S </div> | | | | | | | | | | | | | |

Fwd Bracket Assembly

| | | | | | | | | | | | | | |
|---|--|--------------|----|--|--|-----|------|--------|---|--|--|--|--|
| D4434-047 | | Manufactured | No | | | 110 | Each | 0.0000 | 6 | | | | |
| <div style="display: flex; justify-content: space-between;"> -2 *D4434-047* ** ✓ S </div> | | | | | | | | | | | | | |

Cover Assembly

| | | | | | | | | | | | | | |
|--|--|--------------|----|--|--|-----|------|---------|---|--|--|--|--|
| D4435-045 | | Manufactured | No | | | 110 | Each | 19.0000 | 6 | | | | |
| <div style="display: flex; justify-content: space-between;"> S *D4435-045* ** ✓ S </div> | | | | | | | | | | | | | |

T/R Bellcrank Cover Assembly

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST-441 | 19 | |
| 80650 | 10 | |
| 80651 | 9 | |

3x 82292 JB 3x 83538 SP
4x 82291 2x 85839 SP
3x 82290 JB 12/09/25
3x 83535

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 82285

82285

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 6.00

Required Qty: 6.00

D4435-9 Manufactured No

110 Each

39.0000

D4435-9

Bracket

2 12

** 8x 83474 JB
4x 87534

Location

Loc Qty

Loc Code

ST441

39

80659

39

D4436-041 Manufactured No

110 Each

0.0000

D4436-041

Aft Bracket Assembly

0 6

** 4x 82286 JB
2x 85861 SP

Location

Loc Qty

Loc Code

ST

-9

ST441

9

D4441-1 Manufactured No

110 f

182.6290

D4441-1

Rubber Seal

2 12

** JB 12/09/25

Location

Loc Qty

Loc Code

prelim

6.739

74760

6.739

ST413

175.89

79385

165.99

80763

9.9

80763

D4441-1-240) CUT (1) AT 24.00" PER KIT

AN3-3A

Purchased No

110 Each

701.0000

AN3-3A

Bolt

7 42

** 3x 122416 JB 12/09/26

Location

Loc Qty

Loc Code

ST350

701

120423

701

39 120423

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Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 82285

82285

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 6.00

Required Qty: 6.00

AN525-832R7

Purchased

No

110

Each

640.0000

2 12 ✓

AN525-832R7

Screw

**

JO



Location

Loc Qty

Loc Code

ST345

640

120519

140

120560

500

120560

MS21042L06

Purchased

No

110

Each

370.0000

7 42 ✓

MS21042L06

Nut

**

122151 JB



Location

Loc Qty

Loc Code

ST300

370

118354

2

119109

1

119758

1

120360

366

MS21042L08

Purchased

No

110

Each

388.0000

2 12 ✓

MS21042L08

Nut

**

122452 JB

12/09/21



Location

Loc Qty

Loc Code

ST300

388

120142

19

120648

169

120833

200

March-28-12 12:53:59 PM

Shop Packet Print

Page 3

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 82285

82285

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 6.00

Required Qty: 6.00

MS21042L3

Purchased

No

110

Each

2,666.000

5

30

✓

MS21042L3

Nut

**

122141 JB



Location

Loc Qty

Loc Code

ST300

2666

117441

16

117885

32

118451

5

118927

3

119017

2344

119075

166

121162

100

MS21059L3

Purchased

No

110

Each

247.0000

2

12

✓

MS21059L3

Nut Plate

**

122452 JB



Location

Loc Qty

Loc Code

ST301

28

118614

8

119546

20

ST302

219

120308

19

120833

100

121011

100

MS35206-229

Purchased

No

110

Each

380.0000

7

42

✓

MS35206-229

Screw

**

JB



12/09/21

Location

Loc Qty

Loc Code

ST293

380

121039

380

121039

March-28-12 12:53:59 PM

Shop Packet Print

Page 4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 82285

82285

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 6.00

Required Qty: 6.00

NAS1149F0332P

Purchased

No

110

Each

782.0000

12

72

✓

NAS1149F0332P

WASHER

**

122441 JB

Location

Loc Qty

Loc Code

ST275

782

117735

37

119225

10

120498

132

120910

200

120986

200

121166

200

17317

3

NAS1149FN616P

Purchased

No

110

Each

1,051.000

14

84

✓

NAS1149FN616P

WASHER

**

JB

Location

Loc Qty

Loc Code

ST275

1051

117317

51

120560

1000

NAS1149FN882P

Purchased

No

110

Each

0.0000

2

12

✓

NAS1149FN882P

Washer

**

120560
12/039 JB

12/09/21

846

316P
9/11/12.03.28

March-28-12 12:53:59 PM

Shop Packet Print

Page 5

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. D OR EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 1 OR EARLIER
REF CANADIAN STC: SH92-18
FAA STC: SH989NE
FAA STC: SH990NE

1.0 Purpose

The purpose of this service instruction is to add the D350-567-141 Close-out Kit, which is intended for customers wishing to operate their aircraft with the interior floor window removed. The D350-567-141 Floor Window Close-out Kit provides a barrier around the interior and exterior vertical reference floor window to prevent objects from falling into the aircraft controls when the interior floor window is removed as shown in Figure 1.

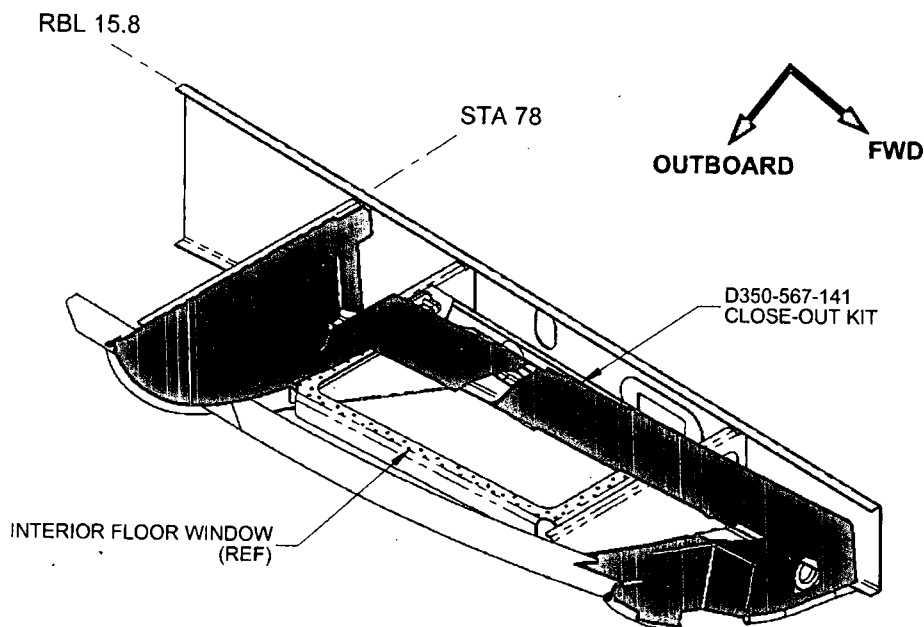


Figure 1. Floor Window Close-out Kit Installation

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82285 MCB

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 12.03.13
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | | |
|------------|--|--|---------------|
| C | CORRECT TYPO NAS1149FN816P WAS NAS1149FN882P | RF | 12.03.13 |
| B | MS35206-229 WAS AN525-632R6; NAS1149FN616P (Qty 14) WAS (Qty 9); MS21042L06 (Qty 7) WAS (Qty 9); ADD AN525-832R7, NAS1149FN882P & MS21042L08 | RF | 12.02.22 |
| A | NEW ISSUE | RF | 12.01.09 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>AS</i> | DRAWING NO. | REV. C |
| MFG. APPR. | N/A | DSI 9590 | SHEET 1 OF 12 |
| APPROVED | <i>AS</i> | TITLE | SCALE |
| DE APPR. | <i>AS</i> | FLOOR WINDOW CLOSE-OUT KIT | NTS |
| DATE | 12.03.13 | COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

2.0 Part List

| Qty -141 | Part Number | Description |
|-------------|---------------|------------------------------|
| X | D350-567-141 | FLOOR WINDOW CLOSE-OUT KIT |
| 1 | D3802-1-024 | SEAL (24") |
| 1 | D4434-041 | FWD BRACKET ASSEMBLY |
| 1 | D4434-047 | COVER ASSEMBLY |
| 1 | D4435-045 | T/R BELLCRANK COVER ASSEMBLY |
| 2 | D4435-9 | BRACKET |
| 1 | D4436-041 | AFT BRACKET ASSEMBLY |
| 1 | D4441-1-240 | RUBBER SEAL (24") |
| 7 | AN3-3A | BOLT |
| 2 | AN525-832R7 | SCREW |
| 7 | MS21042L06 | NUT (OR MS21042-06) |
| 2 | MS21042L08 | NUT (OR MS21042-08) |
| 5 | MS21042L3 | NUT (OR MS21042-3) |
| 2 | MS21059L3 | NUTPLATE |
| 7 | MS35206-229 | SCREW |
| 12 | NAS1149F0332P | WASHER (AN960-10L) |
| 14 | NAS1149FN616P | WASHER (OR AN960-6L) |
| 2 | NAS1149FN816P | WASHER (OR AN960-8L) |



3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

| Installation | Weight | LATERAL | | LONGITUDINAL | |
|----------------------------|---------|---------|------------|--------------|-------------|
| | | Arm | Moment | Arm | Moment |
| D350-567-141 | 3.9 lb | 17.9 in | 69.8 in-lb | 65.5 in | 255.5 in-lb |
| Floor Window Close-out Kit | 1.77 kg | 0.45 m | 0.80 m-k | 1.66 m | 2.94 m-k |

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 — OK to remove D3295-041
 - D350-567-031 — OK to remove D3212-1
 - D350-567-011 — OK to remove D2214
 - D350-567-021 — OK to remove D2951
- It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 12.03.13
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | |
|------------|--------------------|--|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| DRAWN | RF | |
| CHECKED | <u>[Signature]</u> | DRAWING NO. REV. C |
| MFG. APPR. | N/A | DSI 9590 SHEET 2 OF 12 |
| APPROVED | <u>[Signature]</u> | TITLE SCALE |
| DE APPR. | <u>[Signature]</u> | FLOOR WINDOW CLOSE-OUT KIT NTS |
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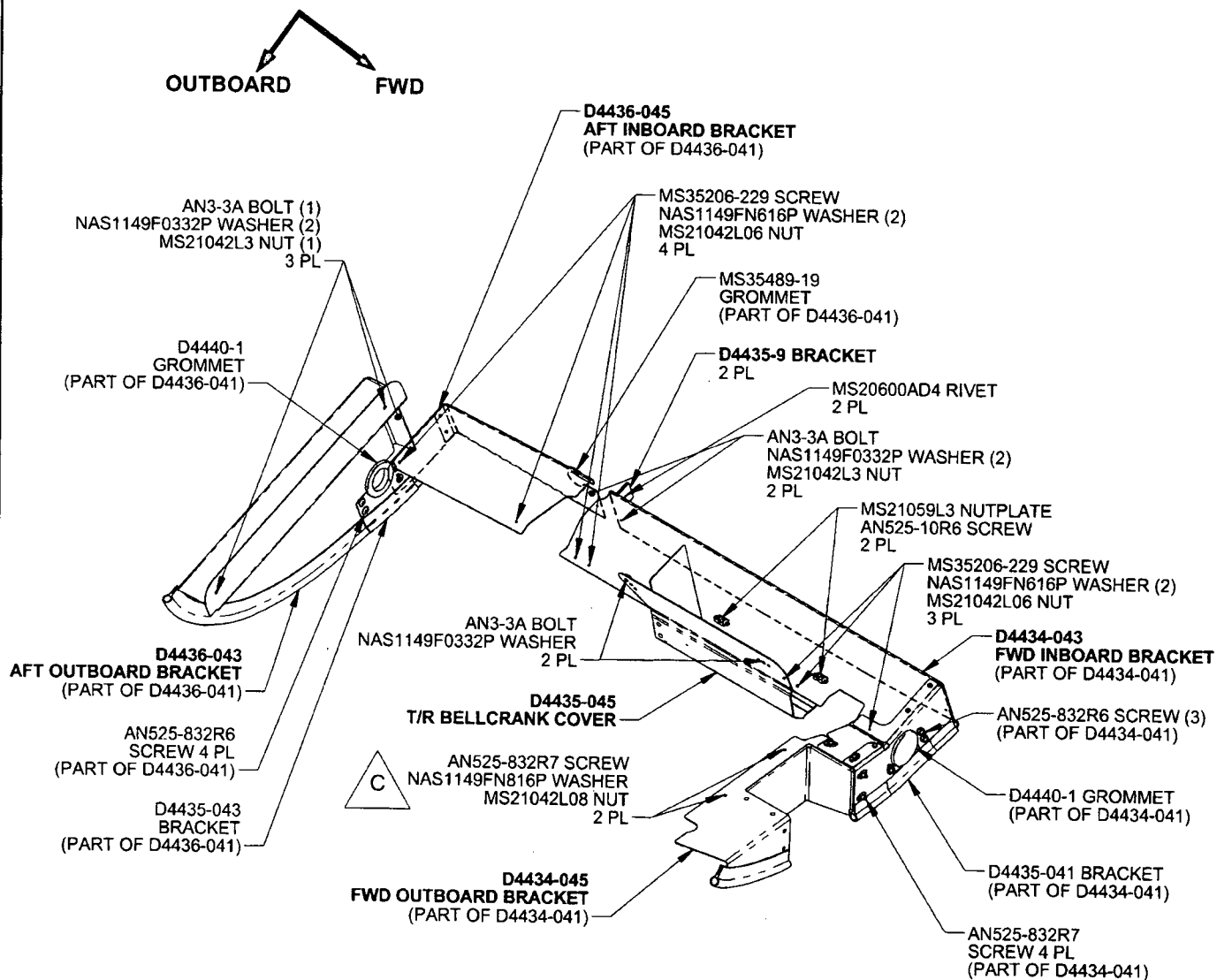


Figure 2. Floor Window Close-out Kit Installation

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DAO # 01-Q-01

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- 4.1 Temporarily install D4436-043 Aft Outboard Bracket and D4436-045 Aft Inboard Bracket using clecos and/or clecos clamps. Before drilling holes:
- Position the D4436-043 Aft Outboard Bracket so the flange contacts the main beam as shown in Figure 3.
 - Confirm that the D4436-043 Aft Outboard Bracket and beam angle are parallel as shown in Figure 4.
- 4.2 Temporarily install D4434-043 Fwd Inboard Bracket and D4434-045 Fwd Outboard Bracket using clecos and cleco clamps. Confirm there is no contact between D4436-045 Aft Inboard Bracket and D4434-043 Fwd Inboard Bracket and main beam gusset as shown in Figure 5.
- 4.3 If aircraft is equipped with Collective Circuit Breaker Board box trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Install D4434-047 Cover as shown in Figure 13. Note: Confirm the D4434-047 Cover fits over the Collective Circuit Breaker Board box. Adjust opening as required.
- 4.4 Drill off rivets holding plastic wire bundle stand offs. Transfer drill $\varnothing 0.144$ holes to D4436-045 Aft Inboard Bracket per Figure 6. Transfer drill 2 x $\varnothing 0.144$ holes to D4434-043 Fwd Inboard Bracket per Figure 7. Transfer drill 2 x $\varnothing 0.144$ holes for D4434-043 Fwd Inboard Bracket per Figure 8. Before drilling confirm the D4434-043 and D4436-045 brackets are flush with outboard edge of main beam flange. Assemble D4436-045 Aft Inboard Bracket and D4434-043 Fwd Inboard Bracket and wire bundle stand offs to main beam flange using MS35206-229 screw, NAS1149FN616P washer and MS21042L06 nut.
- 4.5 Install D4436-043 Aft Outboard Bracket using AN3-3A bolt and NAS1149F0332P washer and MS21042L3 nut per Figure 9.
- 4.6 Remove 2 rivets holding RH heating plastic stand off as shown in Figure 10. Position the D4435-9 Brackets on the in/outboard sides of the cross beam and transfer drill 2 x $\varnothing 0.129$ holes from crossbeam to both D4435-9 Brackets. Install D4435-9 Brackets and RH heating plastic stand off using MS20600AD4 rivets or equivalent.
- 4.7 Drill a pilot hole from D4435-9 Bracket to the D4434-045 Fwd Inboard Bracket and D4436-045 Aft Inboard Bracket and open to $\varnothing 0.191$. Install AN3-3A bolt, NAS1149F0332P washer and MS21042L3 nut as shown in Figure 10. Be sure to maintain edge distance.
- 4.8 Transfer drill 2 x $\varnothing 0.144$ holes from crossbeam to D4434-045 Fwd Outboard Bracket if holes exist in crossbeam. If holes do not exist, drill 2 x $\varnothing 0.144$ holes at either end of D4434-045 bracket as shown in Figure 11. Install AN525-832R7 Screws, NAS1149FN816P washer and MS21042L08 nuts.
- 4.9 Align D4435-045 T/R Bellcrank Cover with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12.
- 4.10 Transfer drill 2 x $\varnothing 0.098$ holes from D4435-045 T/R Bellcrank Cover to D4434-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043 Fwd Inboard Bracket as shown in Figure 12 and Figure 13. Install D4435-045 T/R Bellcrank Cover using AN525-10R6 screw, AN3-3A bolt and NAS1149F0332P washer per Figure 12 and Figure 13.
- 4.11 The D4440-1 grommets are provided to facilitate the routing of wiring harness thru the close-out kit as required. The wiring harness should be secure to the aircraft structure per AC 43.13.13-1B or AS350 Chapter 20.02.01.
- 4.12 Use the D3802-1-024 Seal to fill gaps between the brackets and the cowlings that are larger than 0.25 inch.
- 4.13 Perform travel/interference check of the flight controls to ensure there is no interference and all controls still have full travel.
- 4.14 Ensure there is a gap between the components of the D350-567-141 Close-out Kit and the aircraft structure so that the Close-out Kit does not chafe, interfere, or cause damage to the surrounding aircraft structure. In areas where the D350-567-041 Close-out Kit may contact the aircraft structure, protect from abrasion using chafing tape or a layer Proseal 890 or MIL-S-8802 class B2 sealant or equivalent as required.



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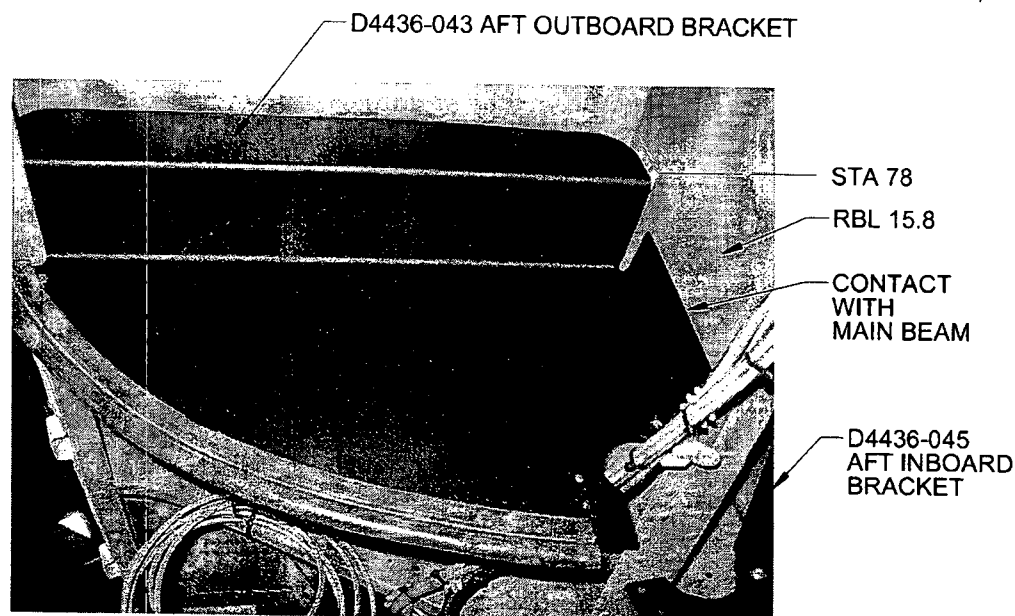


Figure 3. D4436-043 Aft Outboard Bracket Installation

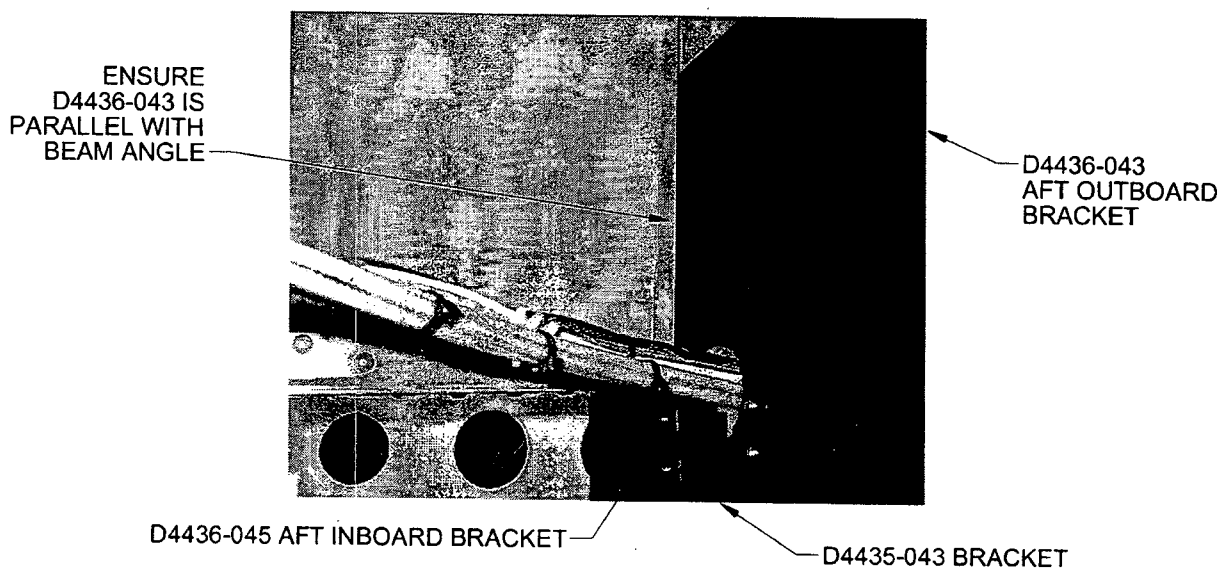


Figure 4. D4436-043 & D4435-043 Brackets Installation

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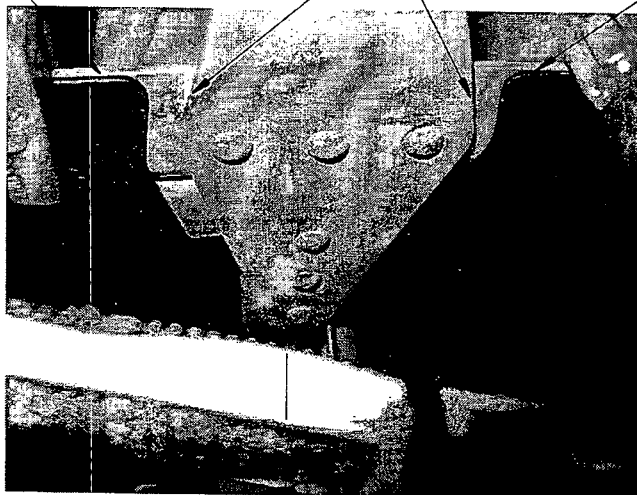
NOTE: Date & initial all entries

D4436-045 AFT INBOARD BRACKET

NO CONTACT WITH GUSSET

D4434-043 FWD INBOARD BRACKET

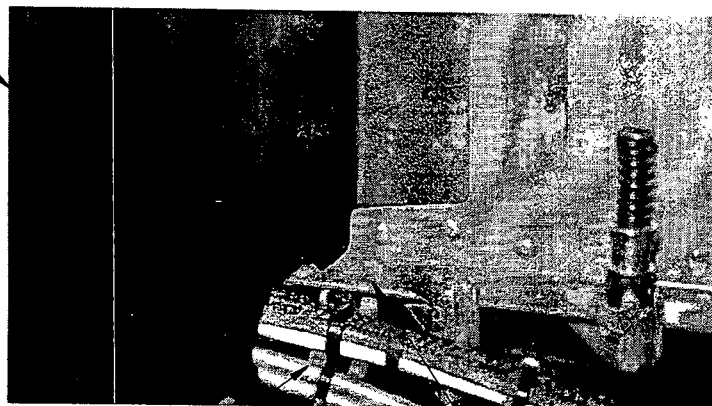
RBL 15.8



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Figure 5. D4436-045 & D4434-043 Brackets Installation

D4436-043 AFT OUTBOARD BRACKET



CONFIRM FLUSH WITH OUTBOARD EDGE OF MAIN BEAM FLANGE

PLASTIC STAND OFF REF

RIVET HOLE FOR PLASTIC STAND OFF

D4436-045 AFT INBOARD BRACKET

Figure 6. D4436-043 & D4436-045 Brackets Installation

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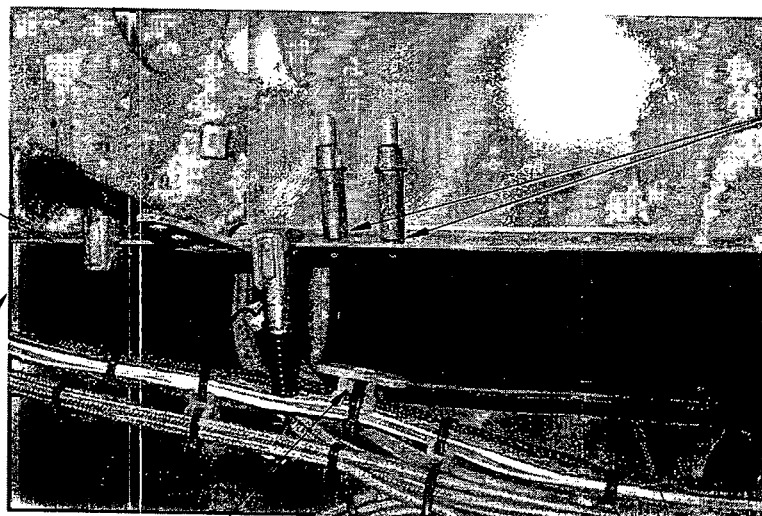
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CONFIRM
FLUSH WITH
OUTBOARD
EDGE OF MAIN
BEAM FLANGE

D4436-045
AFT INBOARD
BRACKET



RIVET HOLES
FOR PLASTIC
STAND OFF

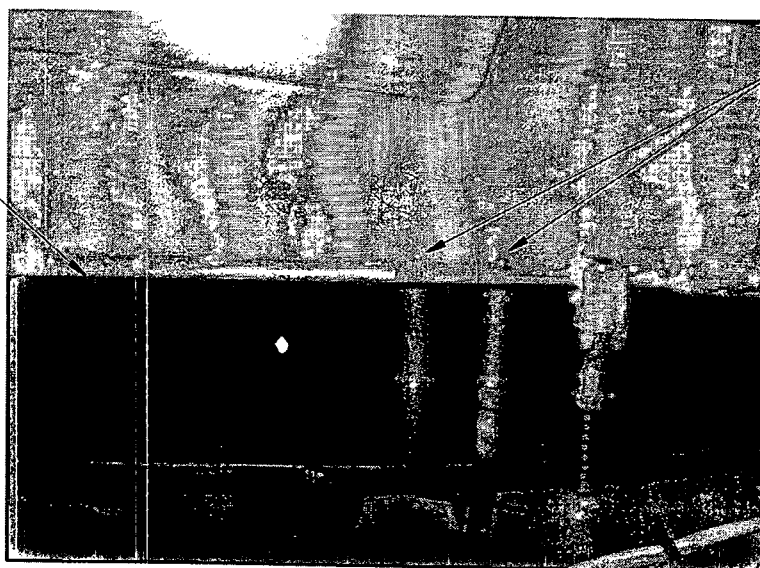
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PLASTIC STAND OFF
REF

D4434-043 FWD INBOARD
BRACKET

Figure 7. D4434-043 & D4436-045 Brackets Installation

CONFIRM
FLUSH WITH
OUTBOARD
EDGE OF MAIN
BEAM FLANGE



RIVET HOLES
FOR PLASTIC
STAND OFF

--- RBL 15.8

D4434-043 FWD INBOARD
BRACKET

Figure 8. D4434-043 Fwd Inboard Bracket Installation

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INSTALL
D4436-043
AFT OUTBOARD BRACKET
USING
AN3-3A BOLT (1)
NAS1149F0332P WASHER (2)
MS21042L3 NUT (1)
3 PL

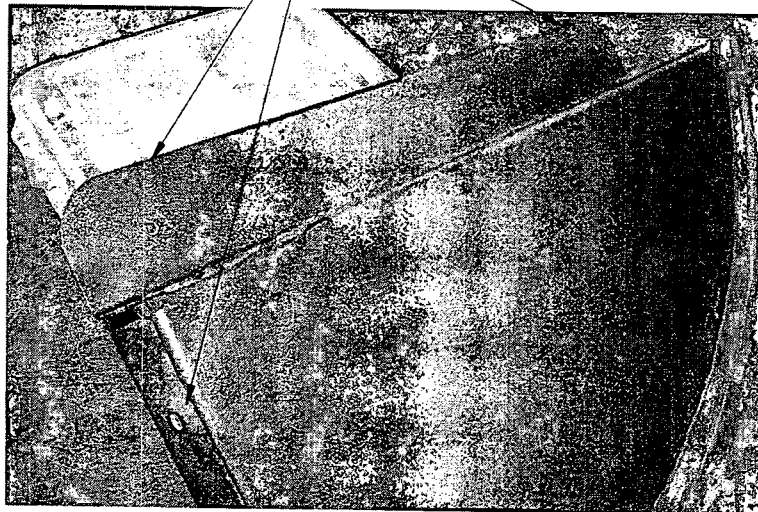


Figure 9. D4436-043 Aft Outboard Bracket Installation

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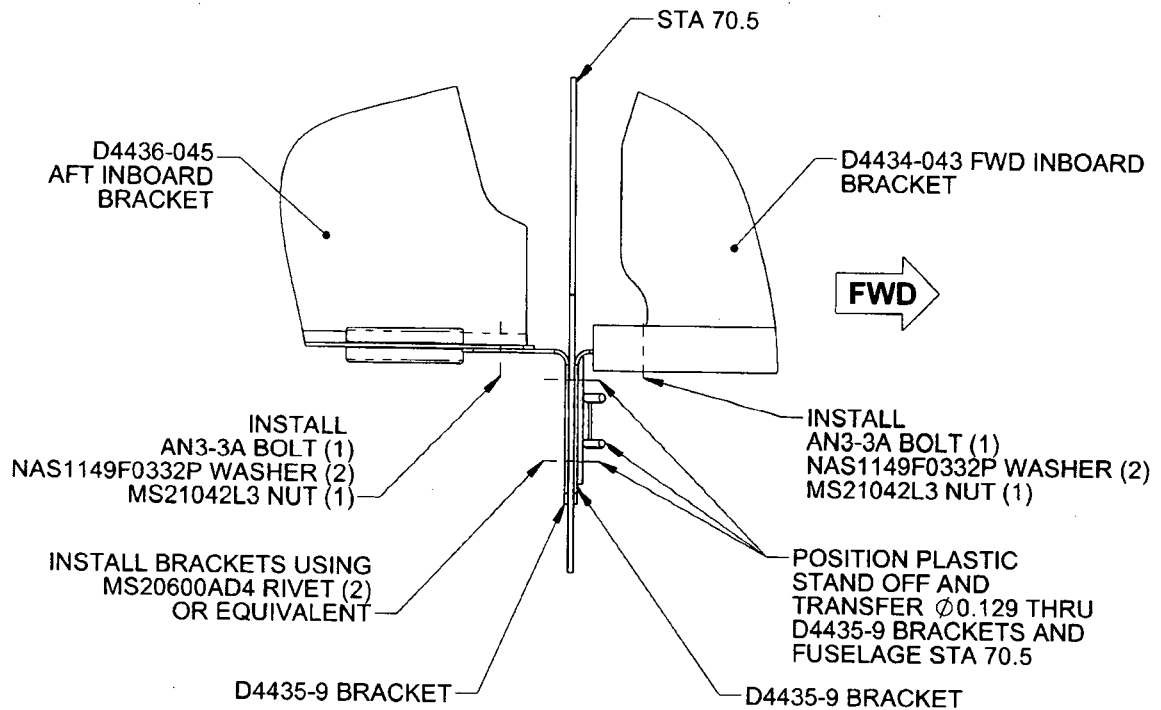
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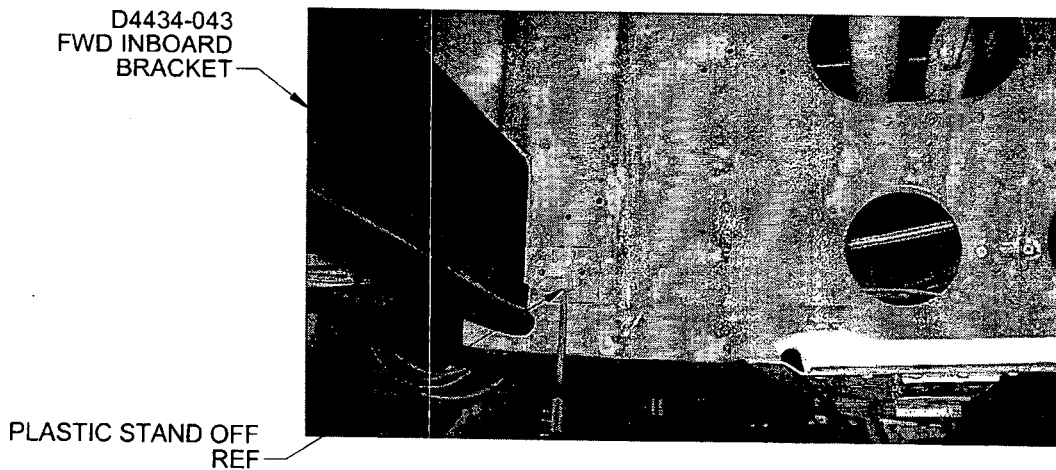


Figure 10. D4434-043 and D4435-9 Brackets Installation

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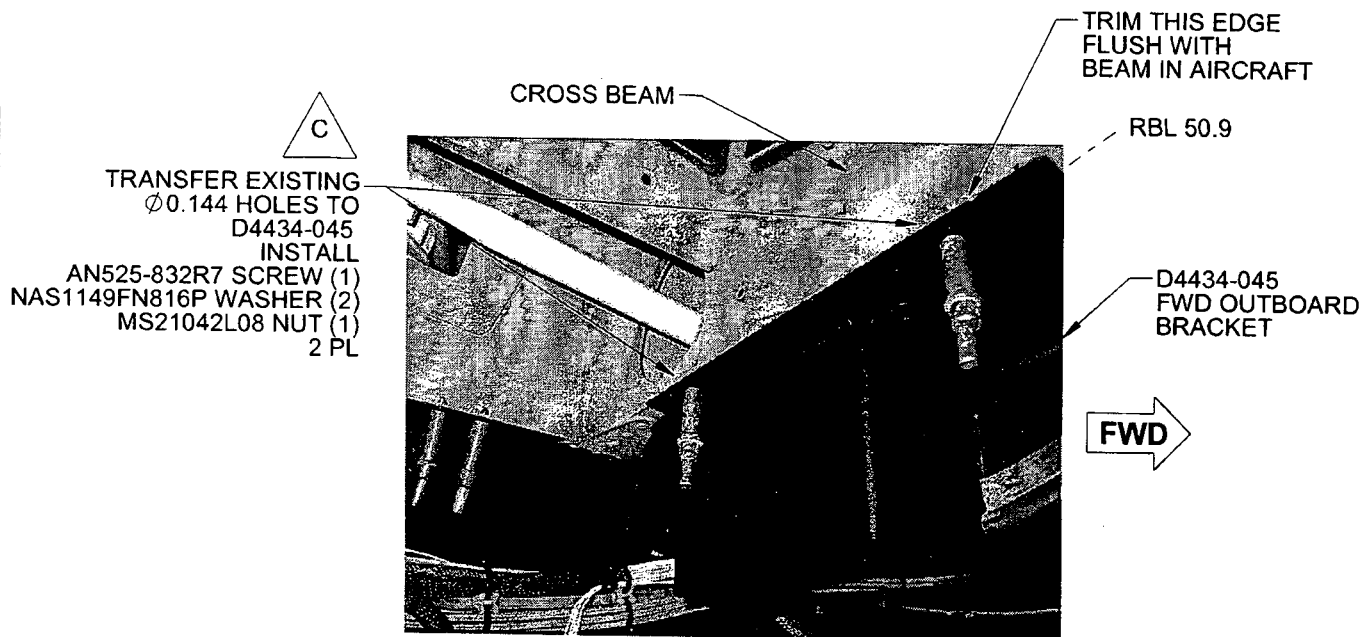


Figure 11. D4434-045 Bracket Installation

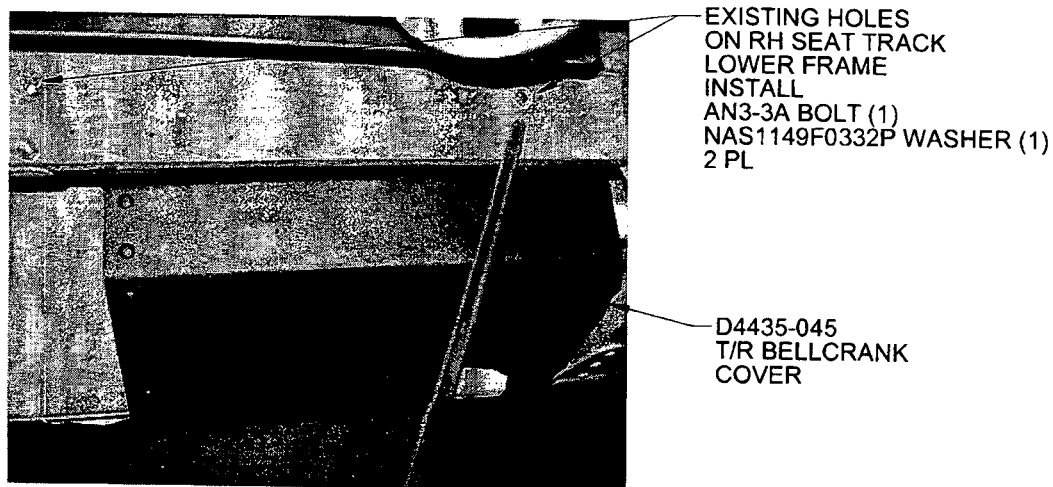


Figure 12. D4435-045 T/R Bellcrank Cover Installation

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

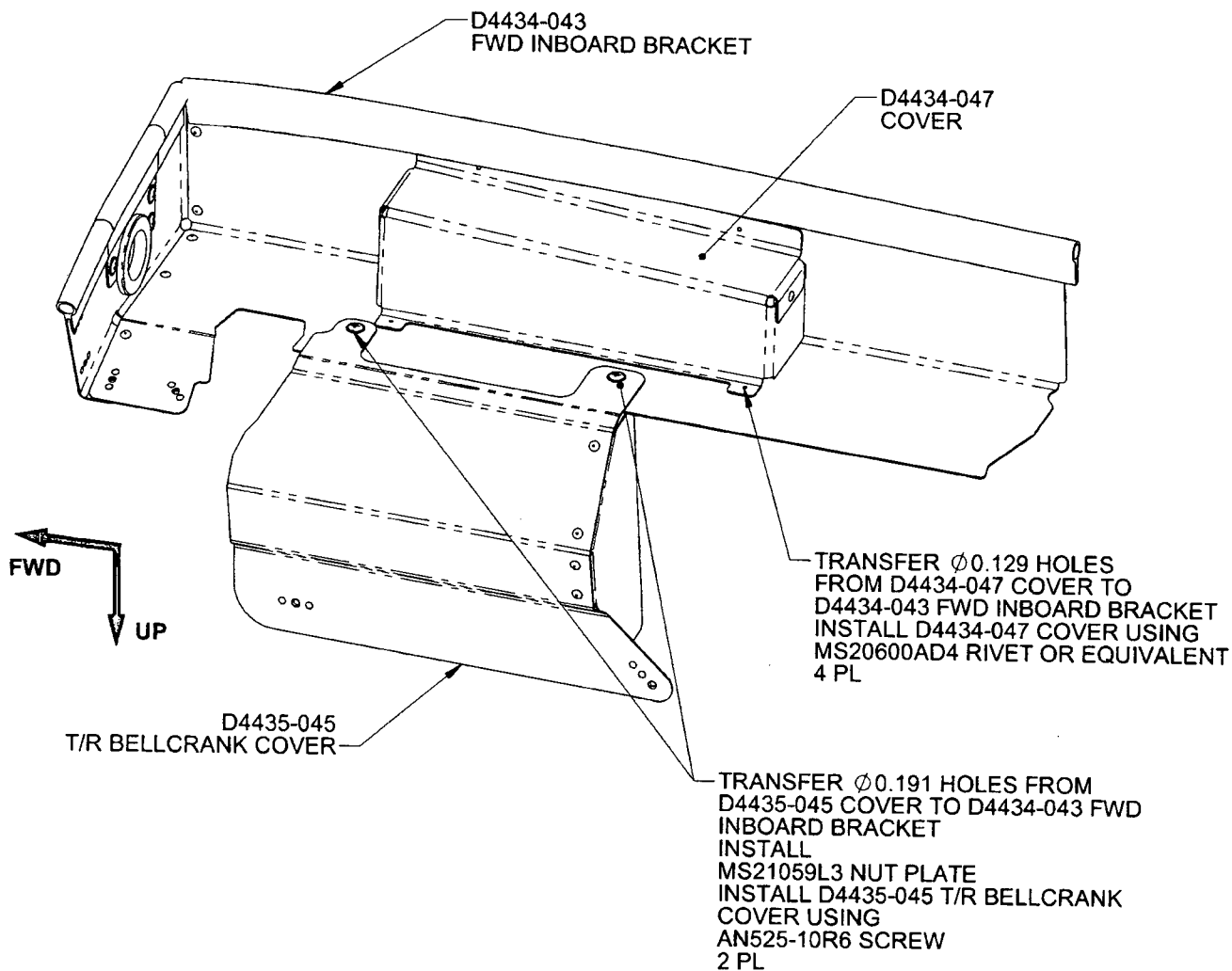


Figure 13. D4435-045 & D4434-047 Cover Installation

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 12.03.13
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| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. DSI 9590 | REV. C |
| MFG. APPR. | N/A | | SHEET 11 OF 12 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | FLOOR WINDOW CLOSE-OUT KIT | NTS |
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0228

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

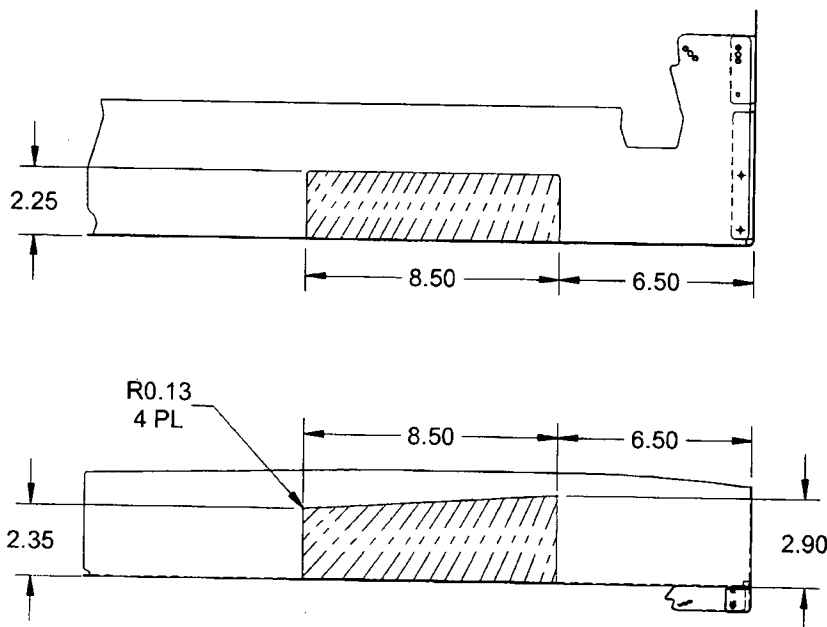
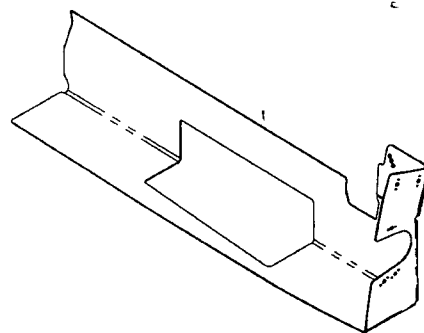


Figure 14. D4434-043 Fwd Inboard Bracket Cutout

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82281

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

• NOTE: Date & initial all entries

REFERENCE ONLY

2.0 Part List

| Qty -141 | Part Number | Description |
|-------------|---------------|-------------------------------|
| X | D350-567-141 | FLOOR WINDOW CLOSE-OUT KIT |
| 1 | D3802-1-024 | SEAL (24") |
| 1 | D4434-041 | FWD BRACKET ASSEMBLY |
| 1 | D4434-047 | COVER ASSEMBLY |
| 1 | D4435-045 | T/R BELL CRANK COVER ASSEMBLY |
| 2 | D4435-9 | BRACKET |
| 1 | D4436-041 | AFT BRACKET ASSEMBLY |
| 1 | D4441-1-240 | RUBBER SEAL (24") |
| 7 | AN3-3A | BOLT |
| 2 | AN525-832R7 | SCREW |
| 7 | MS21042L06 | NUT (OR MS21042-06) |
| 2 | MS21042L08 | NUT (OR MS21042-08) |
| 5 | MS21042L3 | NUT (OR MS21042-3) |
| 2 | MS21059L3 | NUTPLATE |
| 7 | MS35206-229 | SCREW |
| 12 | NAS1149F0332P | WASHER (AN960-10L) |
| 14 | NAS1149FN616P | WASHER (OR AN960-6L) |
| 2 | NAS1149FN816P | WASHER (OR AN960-8L) |

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

| Installation | Weight | LATERAL | | LONGITUDINAL | |
|----------------------------|---------|---------|------------|--------------|-------------|
| | | Arm | Moment | Arm | Moment |
| D350-567-141 | 3.9 lb | 17.9 in | 69.8 in-lb | 65.5 in | 255.5 in-lb |
| Floor Window Close-out Kit | 1.77 kg | 0.45 m | 0.80 m-kg | 1.66 m | 2.94 m-kg |

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 — OK to remove D3295-041
 - D350-567-031 — OK to remove D3212-1
 - D350-567-011 — OK to remove D2214
 - D350-567-021 — OK to remove D2951
- It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: MSH
D. SHEPHERD (DE # 02)

DATE: 12.03.13
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| APPROVED | <u>RF</u> | TITLE FLOOR WINDOW CLOSE-OUT KIT |
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